<b>Work Ord</b> <i>May 19, 2010 S</i>										Page 1			
Item ID: Revision ID:	D206-62		*		Accept					Setup	Start Stop		
Item Name: Start Date: Required Date:	5/19/10	Start Qty: 5.00 Req'd Qty: 5.00				Cust Item :					отор		
Approvals:	Process QC:	Plan:	_ Date:		Tooling: SPC (Y/N):		ate:			Run	Start Stop		1112   111   1121   1131 1112   113   1141   1161
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr		Revision Nbr			¥#4#		-	<del></del> -					<del></del>
DS19500 IIN-D206-628		A Rev F											
		DOCUMENT CONTRO	L		0.00				dara		Be	= 101	05/26
DC		Мето			0.00				///-	W (		المارية	03/28

Document Control

Photocopy blue file and type labels as per PPP D206-628-014 CHG 006

Siolotza

May 19, 2010 9:13:16 AM

Required Date: 5/21/10

Item ID:

D206-628-014

Accept



Draw

Rev.

Setup Start



**Revision ID:** 

Item Name:

Heli-Access-Step RH

**Start Date:** 

5/19/10

Start Qty: 5.00

Reg'd Oty: 5.00



**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Tooling:

Operation

Pick Kit

Description

Run Date:

Plan

Code

Date: SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Accept

Qty

Stop

Reject

**Qty** 

Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID** 

110

Packaging

Packaging

Memo

0.00

0.00

PULL FROM STOCK: 3 X D206-628-014 B36964 2 X D206-628-014 B52160

CHANGE AS FOLLOWS PER ECN10-530:

38× m 107 ou8 REMOVE FROM KITS: 3 7335 M106785 A1960 10416 2 X D3394-041 B 34 833 16 X AN960C416L B 1136 12 32

2 X D2731-7 B 4 56 5 2 X D3394-043 B 4 56 5 1 X D4064-041 B 56 67 16 X AN960C416 B 10099 3

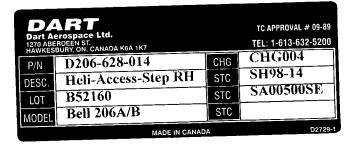
120

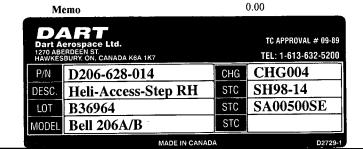
**Quality Control** 

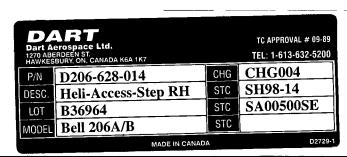
QC4-100% Inspect kits for completeness

0.00 5 (0/67/24

Dart A	PT erospace Ltd. :RDEEN ST. BURY, ON, CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200					
P/N	D206-628-014	CHG	CHG004					
DESC.	Heli-Access-Step RH	STC	SH98-14					
LOT	B52160	STC	SA00500SE					
MODEL	Bell 206A/B	STC						
MADE IN CANADA D2729-1								







## Work Order ID 58822

May 19, 2010 9:13:17 AM



Page 3

Item ID:

D206-628-014

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Heli-Access-Step RH

**Start Date:** 

5/19/10

OC:

Start Qty: 5.00

Required Date: 5/21/10

Req'd Qty: 5.00



Date:

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:\_\_\_\_\_

Tooling:

0.00

0.00

SPC (Y/N):

Set Up/

**Run Hours** 

Run

Stop

Reject

Start

Insp.

Stamp

Sequence ID/ Work Center ID

130

Packaging Packaging

Packaging

**Operation** 

Description

REPACKAGE PER PPP USING NEW B/N @ CHG006

New paperwork 15519500 regid

140

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

Memo

0.00

Reject

Number



Date: Date: Draw Draw Plan Number Rev. Code

Qty Qty 10-5-30 5

Accept

# **Picklist Print**

May 19, 2010 9:13:14 AM

Work Order ID: 58822

D206-628-014

Parent Item Name:

Parent Item:

**Comments:** 

Heli-Access-Step RH

IPP Rev:D As Per Ecn 766 IPP Rev:E

as per ecn 1118 IPP rev F

ncr 09-004

08-02-05 DD verified by:

09.01.09 EC verified by:DD IPP Rev:G

per DSI9500 DD 10.03.01 verified by:JLM

**Start Date:** 5/19/10

Required Date: 5/21/10

Start Qty: 5.00

Required Qty: 5.00



Purchased

Purchased

No

06-01-06 JLM

110

Each

346.0000

Loc Code

16

Location ST346

No

100993

Location

47967

52329

ST469

Loc Qty

346 346

Each

Loc Qty

118

79

39

Each 908.0000



WASHER

AN960C416L

Loc Qty	Loc Code
44	
44	
864	
25	
439	
400	
	44 44 864 25 439

D2731-3

Mounting Lug

Manufactured

118.0000

Loc Code

## **Picklist Print**

May 19, 2010 9:13:14 AM

Page 2

Work Order ID: 58822

Parent Item:

D206-628-014

Parent Item Name:

Heli-Access-Step RH

**Comments:** 

IPP Rev:D As Per Ecn 766

IPP Rev:E as per ecn 1118

06-01-06 JLM 08-02-05 DD verified by:

IPP rev F ncr 09-004 09.01.09 EC verified by:DD IPP Rev:G

per DSI9500 DD 10.03.01 verified by:JLM



**Start Date: 5/19/10** 

Required Date: 5/21/10

Start Qty: 5.00

Required Qty: 5.00

D2731-7 \_\_\_\_\_ Mounting Lug Manufactured

110

Each

71.0000

Location Loc Qty Loc Code ST470 71 41597 23 52330 40 55773 8 Each 44.0000

D3394-041

Manufactured

No

Lug Assembly

Location	Loc Qt	Y	Loc Code
ST474	4	44	
53446		4	
56528	4	40	
	110	Fach	111 0000

D3394-043

Manufactured

Loc Code

Lug Assembly

<u>Location</u>	Loc Oty		
ST475	111		
44521	5		
45365	50		
52331	45		
55772	11		

## **Picklist Print**

May 19, 2010 9:13:14 AM

Page 3

Work Order ID: 58822

Parent Item:

**Comments:** 

D206-628-014

Parent Item Name:

Heli-Access-Step RH

IPP Rev:D As Per Ecn 766 06-01-06 JLM

IPP Rev:E as per ecn 1118 IPP rev F ncr 09-004

08-02-05 DD verified by: 09.01.09 EC verified by:DD IPP Rev:G

per DSI9500 DD 10.03.01 verified by:JLM

**Start Date: 5/19/10** 

Required Date: 5/21/10

Start Qty: 5.00

Required Qty: 5.00

D4064-041

Manufactured

110

Each

13.0000

Location	Loc Qty
ST464	13
56549	3
56671	10
-	

Loc Code

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F

REF FAA STC: SA00500SE REF TCCA STC: SH98-14 REF EASA STC EASA.IM.R.S.01339

#### PURPOSE:

UNMODIFIED D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 005 (OR EARLIER) WILL NOT INSTALL AT THE 18.50" HEIGHT REQUIRED FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

### **CHANGE:**

D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 006 (OR LATER) CONTAIN NEW MOUNTING LUGS FOR COMPATIBLITY WITH APICAL FLOATS.

CONTRARY TO INSTALLATION INSTRUCTIONS IIN-D206-628, FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS, THE D206-628-013/-014 STEP INSTALLATIONS SHOULD BE INSTALLED AT A HEIGHT OF 17.25" PER FIGURE 1 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING THE MOUNTING LUGS, IT IS ACCEPTABLE TO USE LONGER/SHORTER AN4C BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960C416/416L WASHERS UNDER THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

PARTS LIST OF SECTION 5.2 (PG. 12) OF IIN-D206-628-013/-014 REV. F IS AMENDED AS FOLLOWS:

- 1						Description
ı	Х					206 A/B FLOAT STEP INSTALLATION, LH
I		X			D206-628-014	206 A/B FLOAT STEP INSTALLATION, RH

#### WAS:

		 / / / / / / / / / / / / / / / / / / /	
2	2	D2731-3	MOUNTING LUG (EVINOUEL
2	2	D2731-7	MOUNTING LUG PARC
2	2	D3394-041	MOUNTING LUG MINING
2	2	D3394-043	MOUNTING LUG LUG ZUL
16	16	AN960C416L	WASHER MANAGE
	1	 	

### IS:

	1	 <del></del>	
4	4	D2731-7	MOUNTING LUG ADD Z
4	4	D3394-043	MOUNTING LUG 2
1	-	 D4064-041	MOUNTING LUG (NEW)
1	1	 *D4064-1	LUG
2	2	*MS35489-93	GROMMET
	T		
16	16	AN960C416	WASHER 300

<sup>\*</sup> DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

Α	NEW IS	SSUE		CP	10.01.29			
REV.			DESCRIPTION	BY	DATE			
DESIGN DRAWN		9?	DART AEROSPACE USA, INC					
		ap	PORT HADLOCK, WA					
CHECKED		3	DRAWING NO.		REV. A			
MFG, APPR.		NA	DSI 9500		SHEET 1 OF 4			
APPRO'	<b>VED</b>	-#	TITLE		SCALE			
DE APPR.		4	MOUNTING LUG CHANGE					
DATE	10.0		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS FROMTE AND CONTROL AND IS CHIEFED ON THE EXPRESS CONSTITUDING ITS NOT TO BE USED FOR WITHOUT STATES OF THE PERSON WITHOUT TO ANY OTHER PERSON WITHOUT AND THE PERSON WITHOUT THE PERSON FROM DAY ASSOSPACE USA, USA.					